



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3914-041
Job Sheet 179318



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Large Fab-5		2018-06-20
100	Large Fab	1 pcs	7/31/18	7/31/18	0.00	6.67	Large Fab 1		2018-07-09
110	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC9		CPC
120	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC5		CPC
130	Powdercoat	1 pcs	7/31/18	7/31/18	0.00	0.40	Powdercoat4		2018-07-13
135	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC3		18-7-13
140	HandFinish	1 pcs	7/31/18	7/31/18	0.00	0.80	HandFinish3		18-7-12
150	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC3		18-7-17
160	Packaging	1 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3-2		21 JUL 17 2018
170	QC21-SA	1 Ea	7/31/18	7/31/18	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138700 START:8:45 FINISH:9:15 TEMP:320°

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5068733
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5082966
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5083070
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5073266
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5078119
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5066819
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5068261
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5083065

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	75	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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D3914-1	2	3	0
D3914-7	2	2	0
D4016-3	3	25	0
D4018-5	9	30	0
D4020-5	1	6	0
D4021-3	1	33	0
D4035-043	2	0	0

Part Specifications

Specifications could not be found.

Plex 6/18/18 9:12 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rew Sc Use-a Suspected Unappro
Part No. _____	
NCR No. _____	

Date :	Step #:
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Description Work Order Deviation

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QC / QA Coordinator
Approval

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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Past Expiry Date	☐	Manufacturing Process	OTHER :							
Misidentified	☐	Past Due								

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 CANADA
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Container No: S084175
 Part: D3914-041
 Job No: 179318
 Serial No/Batch: S084175
 Revision: A/D
 Inspector:
 Exp Date:
 Instructions:

Date: 06/26/19